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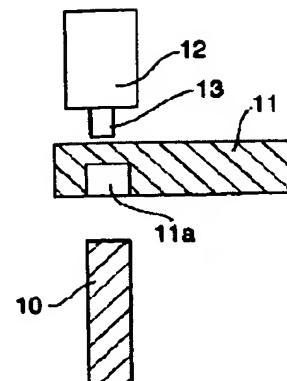
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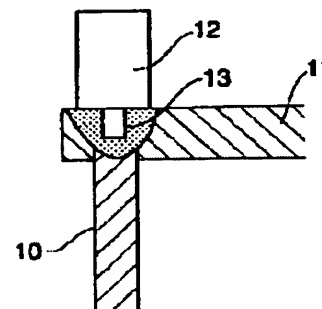
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TITLE : METHOD OF WELDING

(A)



(B)



ABSTRACT : PROBLEM TO BE SOLVED: To provide a method of welding where run-out of a material during a friction stir welding is prevented without using a pressing jig or a supporting member, or without increasing the thickness of the material, thus the machine is made light and the cost of the material is reduced.

SOLUTION: In the method of welding a cover 11 is provided at the opening part of a cylindrical main body 10, and a probe pin 13 made of a material harder than the materials of the cylindrical main body 10 and the cover 11 is inserted while being rotated into the joining part of the cylindrical main body 10 and the cover 11 which are fixed together by moving the probe pin 13 along the joining zone while the pin 13 is rotated. A groove 11a is formed on a face of the cover 11 and the edge of the cylindrical main body 10 is inserted into the groove 11a and moved along the groove 11a while the probe pin 13 is inserted on the face opposite to the groove 11a.

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